

finish rolling the strip from a coil to a coil on a reversing roll stand immediately after the roughing stage in a number of hot rolling passes; suppressing recrystallization of the rolled strip by controlled temperature management of the strip so that last of the hot rolling passes are carried out without recrystallization on the reversing roll stand from coil to coil in a non-critical temperature range of 260°C to a maximum of about 280°C ; coiling the strip into finished coils; and feeding each finished coil to a continuous pusher type furnace for heat treating the finished coils to a recrystallization temperature 315°C to 320°C, as a final step.

C₁
C₂ 7. A plant for carrying out a process for producing hot-rolled aluminum strip for can making, comprising:

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D2 a reversing roughing stage for aluminum feed material which is used hot, the roughing stage being capable of producing a rough strip;

means for finish rolling the rough strip in a number of hot rolling passes so that last of the hot rolling passes occur without recrystallization in a non-critical temperature range of 260°C to a maximum of about 280°C , the finish rolling means including a four-high reversing roll stand and a respective winding device arranged on each side of the roll stand for coiling the strip;

means for heat treating the finish coiled strip to a recrystallization temperature of 315°C to 320°C as a final production stage, the heat treating means including a pusher-type coil furnace and a pallet transport system via which a number of contacting pallets,

each holding a coil, is transported through the pusher-type coil furnace by displacement of the pallets; and

means for transporting the coiled strip to the heat treating means, one of winding devices corresponding with the transporting means.

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